

Date: Tuesday, 7/24/2007 10:47:43 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 33721		
Estimate Number	: 12959		
P.O. Number	:	Part Number	: D36421
This Issue	: 7/24/2007 S.O. No. :	Drawing Number	: D3642 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: AC0005
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: U/R
Previous Run	:	Material	:
Written By	: <u>WLD/07-07-24</u>	Due Date	: 7/31/2007 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07-07-20 JLM	Verified By:EC	

Additional Product

PROTOTYPE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S050 2024-T3 .050 sheet



Comment: Qty.: 0.1747 sf(s)/Unit Total : 0.3494 sf(s)

2024-T3 .050 sheet

Batch: M103321 1B 07-07-30

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3642

Dwg Rev: PROTOProg Rev: TYPE1B 07-07-30

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

1B 07-07-30

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

C'sink as per Dwg D3639

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 33721

Part Number: D36421

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

ENGINEERING APPROVAL WORK TO CURRENT STEP
07-08-08



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

N/A

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



FOR ENGINEERING USE ONLY

w/o 00104.6

W 07-08-15

LE 07.07.17

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DART AEROSPACE LTD		Work Order:	33721
Description: Doubler		Part Number:	D3642-1
Inspection Dwg:	Rev: PROTOTYPE	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.20	+/- .030	5.20	*			
4.85	+/- .030	4.85	*			
4.078	+/- .010	4.078	*			
3.95	+/- .030	3.95	*			
3.05	+/- .030	3.05	*			
2.15	+/- .030	2.15	*			
1.700	+/- .010	1.700	*			
1.25	+/- .030	1.25	*			
.35	+/- .030	.35	*			
.343	+/- .010	.343	*			
.450	+/- .010	.450	*			
1.30	+/- .030	1.30	*			
3.35	+/- .030	3.35	*			
3.47	+/- .030	3.47	*			
3.79	+/- .030	3.79	*			
3.954	+/- .010	3.954	*			
4.666	+/- .010	4.666	*			
4.08	+/- .030	4.08	*			
4.200	+/- .010	4.200	*			
4.60	+/- .030	4.60	*			
Ø .191	+0.05 - .001	.193	*			
Ø .098	+0.04 - .001	.101	*			

Measured by: AB	Audited by:	Prototype Approval: W
Date: 07-07-30	Date:	Date: 07.08.08

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	